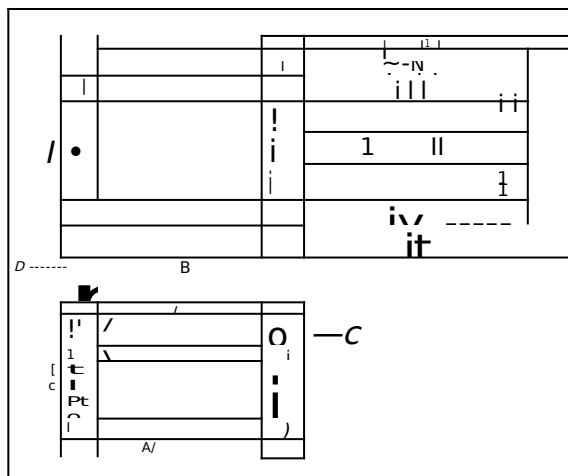


semi-automatic in its action. In this illustration, the body of the jig is shown at *A* and the hinged cover at *B*. This cover swings on the pivot *C* and drops onto the latch *D* which takes the place of the locking screw arrangement shown in Fig. 36, and which shows an application of the principle illustrated in Fig. 30. In cases where the cover is merely used to carry bushings, a latch of this kind is entirely satisfactory, although it is not recommended for use on jigs where screws for holding down the work are carried by the cover. The method of using is evident from the illustration. To swing the cover clear of



**Fig. 35\* Jig with Cover held by Spring Latch**

the work in the jig, the latch *D* is pushed back in the direction of the arrow. After the cover has been raised, the latch springs back into place ready to catch over the top of the cover, when it is dropped back onto the jig. When the cover is dropped, the latch catches it automatically, requiring no attention from the operator.

A number of applications that vary in details only are shown in Figs. 37 to 40. Fig. 37 shows the

style of clamp that is used in connection with *box* drill jigs when it is desired to support a part to be drilled on two points. As will be seen, these two bearing points are self-adjusting. The design of Fig. 38 is generally used when it is desired to support the work in two places in